

Date: Thursday, 3/23/2006 11:10:53 AM
User: COSS systems

Process Sheet

Duplicate of
Split

| | | | | | | | |
|-----------------------|---------------------------------------|----------|-------------------|------------------|----------------------|------|----|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : REPLACEMENT WINDOW | | |
| Job Number | : 25510 <u>2</u> | | | Part Number | : D2942 | | |
| Estimate Number | : 11064 | | | Drawing Number | : D2942 REV.C | | |
| P.O. Number | : N/A | | | Project Number | : N/A | | |
| This Issue | : 3/23/2006 | S.Q. No. | : N/A | Drawing Revision | : C | | |
| Prsht Rev. | : NC | | | Material | : N/A | | |
| First Issue | : 1/16/2006 | Type | : PURCHASED PARTS | Due Date | : 1/31/2006 | Qty: | 20 |
| Previous Run | | | | Um: | Each | | |
| Written By | <u>See comment below</u> | | | | | | |
| Checked & Approved By | <u>SC</u> | | | | | | |
| Comment | : Est. D 01.06.05 New process EC | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|------------------------|
| 1.0 | D2958 | Window | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Window | (1) B 20629 |
| | | Pick: Qty Part Number Description Batch | (2) B 3509 (3) B 21729 |
| 2.0 | D2956 | Window Frame | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Window Frame | (2) |
| | | Pick: Qty Part Number Description Batch | (2) B 3507 |
| 3.0 | D2126 | Seal | |
| | | Comment: Qty.: 5.6250 f(s)/Unit Total : 112.5000 f(s) Seal | (2) |
| | | Pick: Qty Part Number Description Batch | (2) B 24668 |
| 4.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2942 | (2) 06/03/22 (15) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 11:10:53 AM
User: COSS systems

Process Sheet

| Customer: CU-DAR001 Dart Helicopters Services | | Drawing Name: REPLACEMENT WINDOW |
|---|---|---|
| Job Number: 25510 | | Part Number: D2942 |
| Job Number: | |  |
| Seq. #: | Machine Or Operation: | Description : |
| 5.0 | QC5 | INSPECT WORK TO CURRENT STEP |
| |  |  <i>J60324 14 010</i> |
| Comment: INSPECT WORK TO CURRENT STEP | | |
| 6.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| |  |  |
| Comment: PACKAGING RESOURCE #1 | | |
| Identify and Stock | | |
| Location: <u>ST375</u> <i>C Log 103127 14</i> | | |
| 7.0 | DC | DOCUMENT CONTROL |
| |  |  <i>06/03/28 14</i> |
| Comment: DOCUMENT CONTROL | | |
| Inspection Level 21 | | |
| Job Completion | |  <i>06/03/28 u</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: N/A PAR #: XIA Fault Category: NCR 022 NCR: Yes No DQA: D Date: 06/03/28
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|-----------------------------|--|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06.03.24 | 4 | 1 window found with scratch 1" long. | B 06/03/24 | Scrap window and re stock frame and seal. No more windows to replace it | | 2 06.03.24 | B 06/03/24 | 2 06.03.24 |
| 06.03.24 | 4 | 7 windows scratched from trimming and Ass'y | A 06/03/24 | Scrap and destroy | | 2 06.03.24 | B 06/03/24 | 2 06.03.24 |
| | | | | | | | | |

NOTE: Date & initial all entries

Split

Process Sheet

Ref. JI-B-1 Helicopters Services

2

Drawing Name

: REPLACEMENT WINDOW

Customer : S.O. No. :

Part Number : D2942

Type : PURCHASED

Drawing Number : D2942 RE

Project Number : N/A

Drawing Revision :

Material :

Due Date :

Est. E 01.06.05 New process

Qty:

(5) 20 Unit

Each



Seq.

Machine & Operation:

Description :



Quantity : 1.000 Each(s)/Unit Total : 20.000 Each(s)

Part Number : D20629
Description : Window Frame
Batch : B21729

Window Frame

(15)

Quantity : 1.000 Each(s)/Unit Total : 20.000 Each(s)

Window Frame

Part Number : B23307
Description : Window Frame
Batch : B23307

B21729

(15)

Quantity : 50.00 Each/Unit Total : 112.5000 Each(s)

Seal

Part Number : D2126 (67.0)
Description : Seal
Batch : B2126

SAD

06:03:22

(15)

SMALL & MEDIUM FAB RESOURCE 1

Small & Medium FAB RESOURCE 1

Assemble as per Engg D2942

SB 06/03/23 K

Process Sheet

100% Complete
Flightline Helicopters Services

Drawing Name: REPLACEMENT WINDOW

Part Number: D2942



Flightline Helicopters Services

Description:

INSPECT WORK TO CURRENT STEP



INSPECT WORK TO CURRENT STEP



PACKAGING RESOURCE #1



PACKAGING RESOURCE #1

Identifying Name: D2942

Location:

DOCUMENT CONTROL



Document Control

revision level: Q1

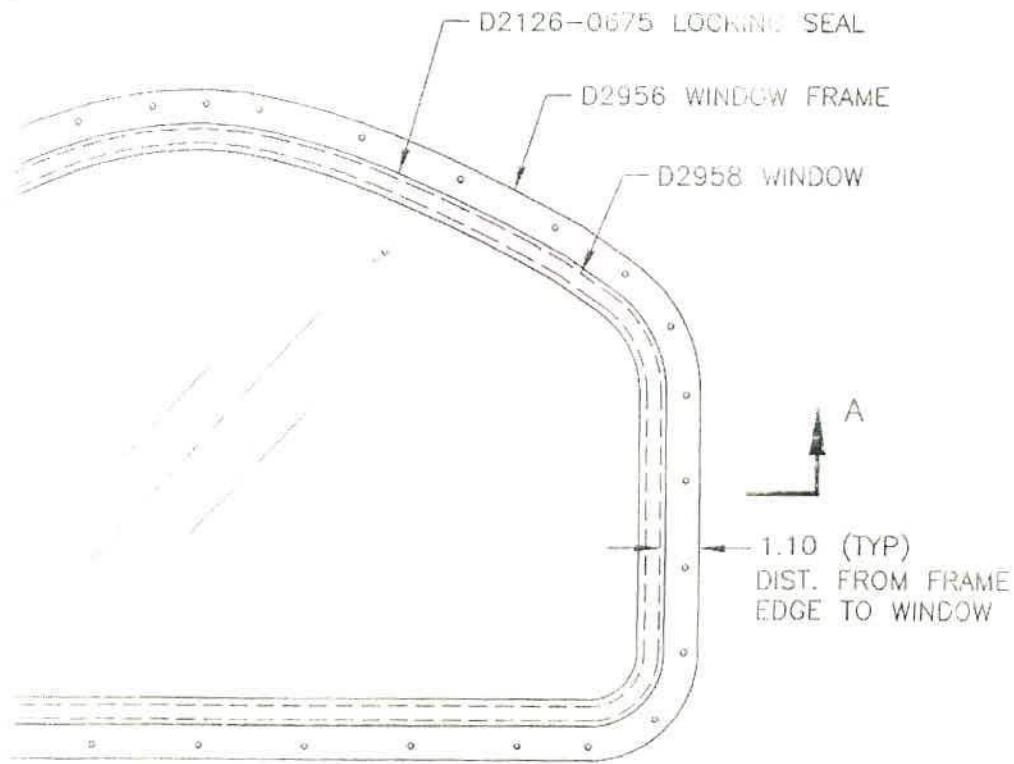


Lev/03/22 (5)

Lev/03/23

DRAFT COPY

| | | |
|----------|----------|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D2942 |
| | | REV. C SHEET 1 OF 1 |
| DATE | | TITLE |
| 01.05.31 | | REPLACEMENT WINDOW |
| A | 00.01.20 | NEW ISSUE |
| B | 00.02.23 | CHANGED FROM RIVET TO SCREW; NOW SEALED ON EDGE ONLY (NCR 407) |
| C | 01.05.31 | WINDOW NOW INSTALLED WITH SEAL |



D2126-0675 LOCKING SEAL
(REF)

SECTION A-A
NOT TO SCALE

ENSURE D2958 WINDOW IS INSTALLED
ON CORRECT SIDE OF D2956 WINDOW FRAME

ALL DIMENSIONS ARE IN INCHES
EXCEPT WHERE NOTED
PER DART QSI 018 UNLESS OTHERWISE NOTED

251C

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